

Work Order ID 163051

Tuesday, September 12, 2017 10:06:41 AM

163051

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Item ID: D3953-21 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gas Spring Bracket
Start Date: 7/14/2017 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 7/18/2017 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						16	Ø		SEP 14 2017
QC	Memo	0.10							DAS 9 9-89
Quality Control									
130		0.00							
130						16x			17/09/18
Small Fab	Memo	0.18							DAS 36 9-89
Small Fab	1- CHAMFER HOLE AS PER DWG								
	2- DEBURR IF NECESSARY								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						16	Ø		SEP 19 2017
QC	Memo	0.10							DAS 9 9-89
Quality Control									DAS 19 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location <u>Stoel</u>	0.00							
150									
Packaging	Memo	0.05				16	6		
Packaging							9-89		
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.50							
Quality Control									

SEP 20 2017

17/9/21

17/9/20

Picklist Print

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Work Order ID: 163051

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Parent Item: D3953-21

D3953-21

Parent Item Name: Gas Spring Bracket

Start Date: 7/14/2017

Required Date: 7/18/2017

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
dwg revC DD 10.03.02 verified by:EC
IPP Rev:B as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	79.1800	0.0144	0.242526			DAS
M304S11GA									**			17/09/13	40
304/316 0.125 Sheet													9-89

Location

Loc Qty

Loc Code

MAT020

79.18

M137110

0.82

M137599

14.36

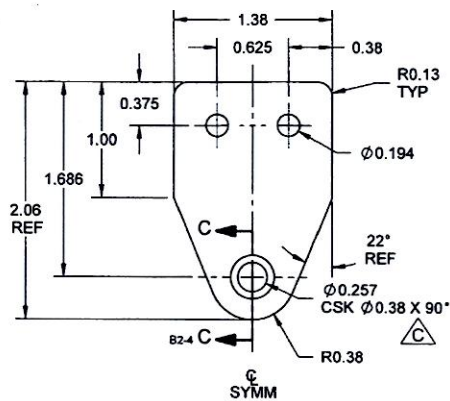
M138109

32

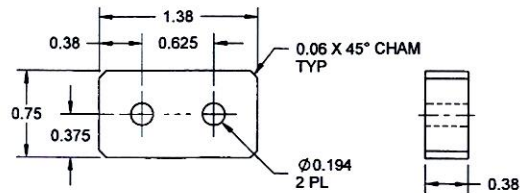
M138346

32

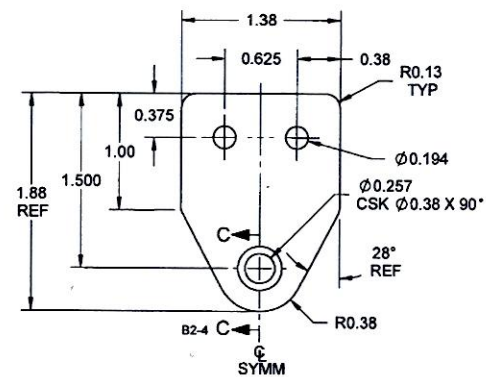
0,3



D3953-15 GAS SPRING BRACKET
(SPLIT LID)

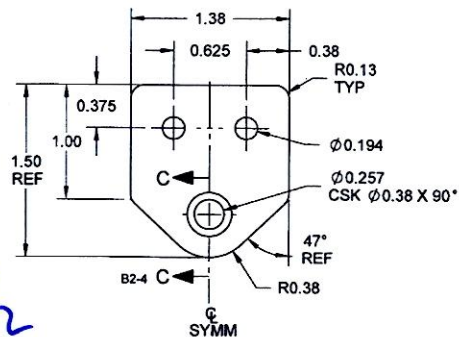


D3953-17 GAS SPRING SPACER
(SPLIT LID)

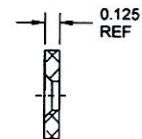


D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163057
12-09-12



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

-19: 0.07 lbs

-21: 0.06 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	B	D3953	SHEET 4 OF 4
APPROVED	J	TITLE	SCALE
DE APPR.	J	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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